



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-4-4A

Job Sheet 193448



REPRINT

Part No: C45-4-4A

Job Qty: 7 pcs

Part Name: C45 Load Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-4-4A REV 20 IPP REV A 18.02.13 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Conventional Lathe - 1	7 pcs	5/10/19	5/10/19	0.00	0.00	Conventional Lathe - 2		
95	Rework	7 pcs	5/10/19	5/10/19	0.00	0.00	QC 2 - 14		
							QC 2 - 63		
100	Small Fab - 1	7 pcs	5/10/19	5/10/19	0.08	0.47	External Load - 1		
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
101	Small Fab - 2 - B4B	7 pcs	5/10/19	5/10/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	7 pcs	5/10/19	5/10/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

not attached



Container No: S195984



Part: C45-4-4A

Job No: 193448

Serial No/Batch: S195984

Revision: 20

Inspector:

Exp Date:

Instructions:

Date: 08/15/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 7/29/19 12:36 PM Dart.Renwick.Jennifer

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130	Outsource - 15 - Nickel Plate	7 pcs	5/10/19		GRO002-VC	5
140	Packaging 2-1 - Receive - B4B	7 pcs	5/10/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150	QC 6	7 pcs	5/10/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
151	Rework - 1 - Startup	7 pcs	5/10/19		GRO002-VC	
152	Rework	7 pcs	5/10/19	0.00 0.00	Packaging 2 - 1 - B4B	
153	Rework	7 pcs	5/10/19	0.00 0.00	QC 6 - 40	
160	Packaging 3-1 - Stock - B4B	7 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	

See Attached

AUG 07 2019

AUG 15 2019

					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					170 QC 21 - FG	7 pcs	5/10/19	0.00 0.00	QC 21 - FG - 21	DAS
									QC 21 - FG - 70	21 AUG 15 2010
									QC 21 - SA - 53	9-60

Part Op 100 - (Small Fab) ASSEMBLE AS PER DWG

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - Outsource15 (Outside Processing - Nickel Plate) -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs)

150 - (QC6- All purchased or subcontracted products)

151 - -Issue P/O; 44220 -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E --Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required

152 - PAC 2

153 - QC 6

160 - (Identify as per dwg & Stock Location: _____)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-4-2-PO	Trunnion, Load Beam	7 pcs (1 ea)	90-Conventional Lathe - 1	
C45-4-4	Load Beam	7 pcs (1 ea)	90-Conventional Lathe - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Conventional Lathe - 1	C45-4-2	7	3	0
	C45-4-4	7	1	0

Part Specifications

Specifications could not be found.

Plex 7/29/19 12:36 PM Dart.Renwick.Jennifer



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C45-4-4A
Job Sheet 193448



Part No: C45-4-4A

Job Qty: 7 pcs

Part Name: C45 Load Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-4-4A REV 20 IPP REV A 18.02.13 NEW ISSUE FK VERIFY DP

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Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Conventional Lathe - 1	7 pcs	5/10/19	5/10/19	0.00	0.00	Conventional Lathe - 2	DAS 63 19/7/49-89
95	Rework	7 pcs	5/10/19	5/10/19	0.00	0.00	QC 2 - 14	
100	Small Fab - 1	7 pcs	5/10/19	5/10/19	0.08	0.47	External Load - 1	
							External Load - 2	
							External Load - 3	
							Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
101	Small Fab - 2 - B4B	7 pcs	5/10/19	5/10/19	0.00	0.00	Small Fab - 1 - B4B	Muel AP 20 19/07/05
110	QC 5	7 pcs	5/10/19	5/10/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
130	Outsource - 15 - Nickel Plate	7 pcs	5/10/19	5/10/19			GRO002-VC ULT0012	DAS 40 9-89 JUL 05 2019 2019-07-10



Container No: S195984



Part: C45-4-4A

Job No: 193448

Serial No/Batch: S195984

Revision: 20

Inspector:

Exp Date:

Instructions:

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/04/19

140 Packaging 2-1 - Receive - B4B 7 pcs

5/10/19

0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 - B4B

Packaging 2 - 11 - B4B

Packaging 2 - 12 - B4B

Packaging 2 - 13 - B4B

Packaging 2 - 14 - B4B

Packaging 2 - 15 - B4B

Packaging 2 - 16 - B4B

Packaging 2 - 17 - B4B

Packaging 2 - 18 - B4B

Packaging 2 - 19 - B4B

Packaging 2 - 20 - B4B

Packaging 2 - 21 - B4B

Packaging 2 - 22 - B4B

Packaging 2 - 23 - B4B

Packaging 2 - 24 - B4B

Packaging 2 - 25 - B4B

Packaging 2 - 26 - B4B

Packaging 2 - 27 - B4B

Packaging 2 - 28 - B4B

Packaging 2 - 29 - B4B

Packaging 2 - 30 - B4B

Packaging 2 - 31 - B4B

Packaging 2 - 32 - B4B

Packaging 2 - 33 - B4B

Packaging 2 - 34 - B4B

Packaging 2 - 35 - B4B

Packaging 2 - 36 - B4B

JUL 23 2019

150 QC 6

7 pcs

5/10/19

0.00 0.00

QC 6 - 9

QC 6 - 68

QC 6 - 61

QC 6 - 40

DAS
40
9-89

AUG 15 2019

160 Packaging 3-1 - Stock - B4B 7 pcs

5/10/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170	QC 21 - FG	7 pcs	5/10/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op **100** - (Small Fab) ASSEMBLE AS PER DWG
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - Outsource15 (Outside Processing - Nickel Plate) -Issue P/O to WIT002 43954 -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required
140 - (Receive & Inspect for Damage & Mat'l Certs)
150 - (QC6- All purchased or subcontracted products)
160 - (Identify as per dwg & Stock Location: _____)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
C45-4-2-PO	Trunnion, Load Beam	7 pcs (1 ea)	100-Small Fab - 1	<u>5125611</u>
C45-4-4	Load Beam	7 pcs (1 ea)	100-Small Fab - 1	<u>5164557</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	C45-4-2	7	10	0
	C45-4-4	7	8	0

Part Specifications				
Specifications could not be found.				

					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - FG	20 pcs	5/10/19	0.00	0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 100 - (Small Fab) ASSEMBLE AS PER DWG

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - Outsource15 (Outside Processing - Nickel Plate) -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs)

150 - (QC6- All purchased or subcontracted products)

160 - (Identify as per dwg & Stock Location:_____)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-4-2	Trunnion, Load Beam	20 pcs (1 ea)	100-Small Fab - 1	⑤ S125611
C45-4-4	Load Beam	20 pcs (1 ea)	100-Small Fab - 1	⑤ S164471 ④ S125611 P ⑤ S164557

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	C45-4-2-PO	20	16	0
	C45-4-4	20	8	0

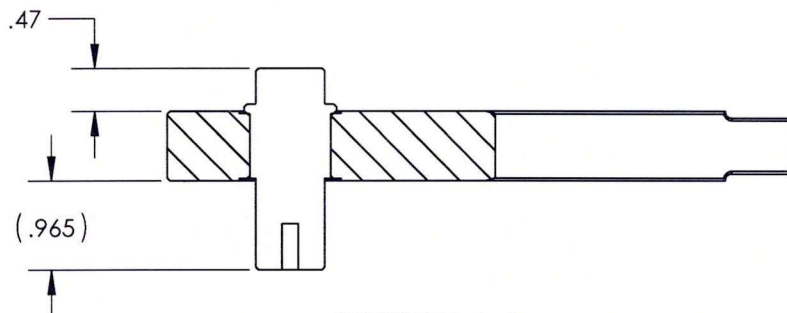
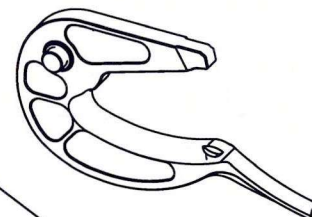
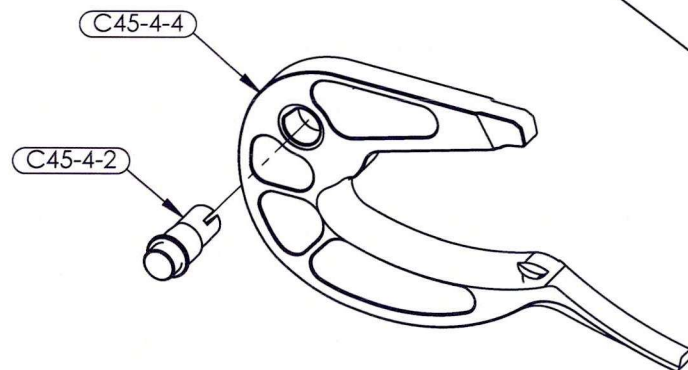
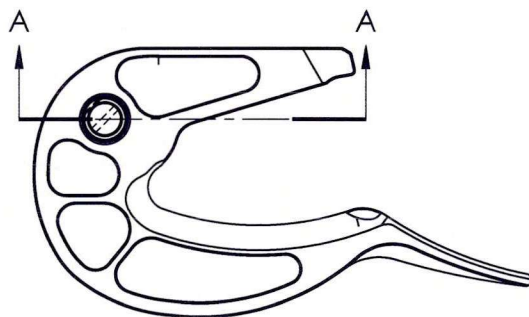
Part Specifications

Specifications could not be found.

Plex 4/15/19 12:52 PM Dart.lajeunesse.marie

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
15		AS RELEASED BY CANAM.	9/18/2012	
16		CH'D DESIGN, REMOVED PIN AND ADDED FLAT TO TRUNNION AND LOAD BEAM	10/30/2012	JAG
17		ADDED NICKEL PLATE BAKE NOTE	12/5/2013	JAG



SECTION A-A
SCALE 1:2

C45-4-4A

C45 LOAD BEAM ASSY.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193448 M.C.
190415

NOTE:
1. NICKEL PLATE .0009 - .0011, BAKE AFTER PLATING.

DART AEROSPACE	
TITLE C45 LOAD BEAM ASSEMBLIES	
DWG NO. C45-4-4A / C45-4-4KA	REV 20
MAT'L HEAT TREAT FINISH SEE NOTE 1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CANAM CHECKED: DD 06/05/2017 OPPS APPR: AA 06/06/2017 QA APPR: JL 06/14/2017 APPROVED: JAG 06/15/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL
SCALE 1:4	DATE 11/17/2009
SHEET 2 OF 6	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043954



Supplier: ULT002-VC
Ultraspec Inc.
2600 De Miniac
St Laurent
QC
H4S 1W5 Canada
Phone: 5143371782
Fax: 5143371784

PO No: POHB043954
PO Date: 7/9/19
Due Date: 7/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms: Prepaid
Special Comments:

E-MAILED
2019-07-15

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193448	C45-4-4A	C45 Load Beam Assembly Outsource15 (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required	Firmed	-	7/22/19	7 pcs	0 pcs	7 pcs	\$10.48/pcs	\$73.36
							7 x JUL 23 2019				
							5195984				
2	193895	C3-12-3	Lock - C3 Hook (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 - Certificate of Conformity is required	Firmed	-	7/22/19	20 pcs	0 pcs	20 pcs	\$5.25/pcs	\$105.00
							20 x JUL 23 2019				
							5190711				
3	197132	C10-9-4	Latch Shaft Bearing (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	7/22/19	27 pcs	0 pcs	27 pcs	\$5.80/pcs	\$156.60
							27 x JUL 23 2019				
							5194938				



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PURCHASE ORDER

POHB043954



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196337	4.5NR-10	Lock Roller Pin Outside Processing - Nickel Plate -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 Bake after plating - Certificate of Conformity is required	Firmed	-	7/22/19	30 pcs	0 pcs	30 pcs	\$5.80/pcs	\$174.00
							30 x JUL 23 2019				
											5193819.
5	193897	C3-13-4	KEEPER Outside Processing - Nickel Plate -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	7/22/19	20 pcs	0 pcs	20 pcs	\$5.25/pcs	\$105.00
							20 x JUL 23 2019				
											5192911
6	193861	C10-4	Lock (Outside Processing - Nickel Plate) -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	7/22/19	12 pcs	0 pcs	12 pcs	\$6.75/pcs	\$81.00
							12 x JUL 23 2019				
											5191999
Grand Total:										\$694.96	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/15/19 4:14 PM Dart.Guerin.Kimberley



CERTIFICAT DE CONFORMITÉ / CERTIFICATE OF COMPLIANCE

BON DE LIVRAISON / PACKING SLIP

047069-1

BUYER:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN ST.

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Livrer À / Ship To:

DART AEROSPACE LTD

1270 ABERDEEN ST.

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Date	Généré Par Generated By	Packaging Paquets	Vendor Code Code Vendeur	Transport	Customer PO / BC Client
22-Jul-2019	Fadi Suleman				POHBO43954

#	No. de Serie / Part Number Line Item Details	Description/Information Additionnelle Additional Information	Commandée Ordered	Acceptée Accepted	Rejetée Rejected
1	C45-4-4A Rev. 	C45 LOAD BEAM ASSY. Job No./WO. 193448 GLASS BEAD BLAST WITH NO. 7 GRADE PER MIL-STD-1504, REV. C ELECTROLESS NICKEL PLATING PER ASTM-B-733, REV. 15, TYPE IV, CLASS 1, SC3	7	7 	0

MAT: ---

Prog./Prime: /COMM.

DAS
61
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JUL 22 2019

DART AEROSPACE LTD.

CERTIFICATE OF COMPLIANCE : I certify that the parts included on this certificate have been processed as per specifications listed above and conform to all the requirements detailed in the contract or purchase order, this compliance is supported by a thorough inspection of parts and regular qualification of material processing facilities

Ultraspec Inc.

Authorized Signature : 

Fadi Suleman

Parts

Received by : _____

All claims with reference to this order must be made within 30 days from receipt of good.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>193448</u> Part No. <u>C45-4-4A</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐			
Date : <u>19/07/23</u>	Sequence #: <u>130</u>	QTY Affected : <u>7 of 7</u>		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
<u>Nickel plate flaking off</u> ANDREW! CAN YOU GET A PIC OF THE PART AND SEND IT TO HOLLY? WHAT'S GOING ON WITH IT?				<u>DAS</u> <u>61</u> <u>9-89</u>	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044220



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044220

PO Date: 8/7/19

Due Date: 8/14/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-08

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198524	PC250-300A	Load Beam Assembly (Outside Processing - Nickel Plate) -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	8/14/19	2 pcs	0 pcs	2 pcs	\$58.2169/pcs	\$116.43
						2X AUG 15 2019					
						5201902					
2	197132	C10-9-4	Latch Shaft Bearing -Issue P/O; -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E --Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	27 pcs	0 pcs	27 pcs	\$3.0669/pcs	\$82.81
						27 X AUG 15 2019					
						S194938					



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PURCHASE ORDER

POHB044220



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	193448	C45-4-4A	C45 Load Beam Assembly -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	7 pcs	0 pcs	7 pcs	\$25.5169/pcs	\$178.62
							7X				
							AUG 15 2019				
							5193448				
4	193895	C3-12-3	Lock - C3 Hook -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	20 pcs	0 pcs	20 pcs	\$3.4669/pcs	\$69.34
							20X				
							AUG 15 2019				
							5190711				
5	193897	C3-13-4	KEEPER -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	20 pcs	0 pcs	20 pcs	\$2.3669/pcs	\$47.34
							20X				
							AUG 15 2019				
							5192911				
6	196337	4.5NR-10	Lock Roller Pin -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	30 pcs	0 pcs	30 pcs	\$2.0669/pcs	\$62.01
							30X				
							AUG 15 2019				
							5193819				
7	193861	C10-4	Lock -Issue P/O; _____ -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/14/19	12 pcs	0 pcs	12 pcs	\$4.5169/pcs	\$54.20
							12X				
							AUG 15 2019				
							5191999				
Grand Total:										\$610.74	

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044220



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/8/19 3:29 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021397-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021397 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.
14-Aug-2019	Jigar Patel		POHB044220 ✓

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	PC250-300A ✓ Rev.	PC250-300A E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0009 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL-200 CH	2	2 ✓	0	0	0
2	C10-9-4 ✓ Rev.	C10-9-4 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	27	27 ✓	0	0	0
3	C45-4-4A ✓ Rev.	C45-4-4A E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0009 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL ALUM CH	7	7 ✓	0	0	0
4	C3-12-3 ✓ Rev.	C3-12-3 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0005 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	20	20 ✓	0	0	0
5	C3-13-4 ✓ Rev.	C3-13-4 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	20	20 ✓	0	0	0
6	4.5NR-10 ✓ Rev.	4.5NR-10 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	30	30 ✓	0	0	0

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AUG 15 2019

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E-MAL



Certificat de Conformité / Certificate of Compliance

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 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

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Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Aug-2019		Jigar Patel		POHB044220				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
7	C10-4 Rev.	C10-4 E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0004 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL STEEL CH	12	12	0	0	0
8	BAKING CHARGE Rev.	BAKING CHARGE 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	1	1	0	0	0

Notes Additionnelles / Additional Notes

2 mid-size
Boxes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.